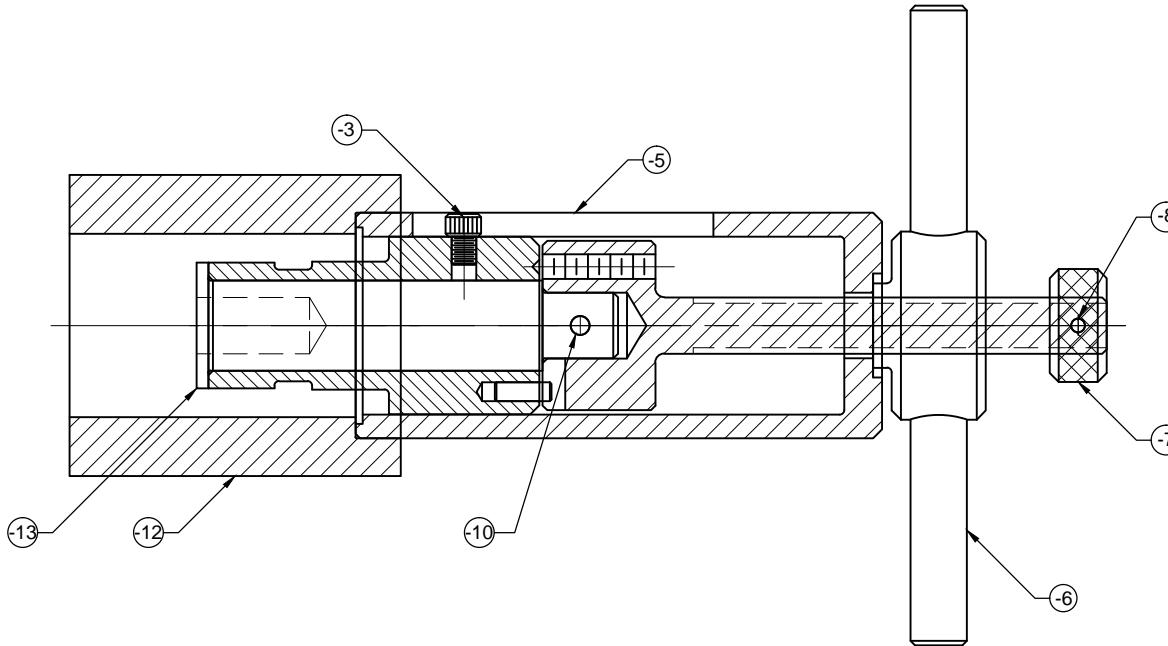


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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC	DW
1	CORRECTED SHEET ONE ASSY VIEW. CH'D -2 DOWEL PIN HOLE FROM Ø.125 DEPTH .38 P.F. -9 SEE NOTE 1, CH'D -7 HOLE CALLOUT FROM Ø.0937-.0932 THRU S.F. -8 AT ASSY. CH'D -11 HOLE FROM Ø.0937-.0928 P.F. -8 AT ASSY. & ADDED MISSING DOWEL PIN HOLE & ADDED .250 ±.003 DIMENSION, CH'D -13 HOLE FROM Ø.1250-.1245 P.F. -10 AT ASSY.	5/29/12	RJC	GE



UNDER REVIEW

URF 19-947 19.10.23 (VM)

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
1			-1		LOCATOR	4140	Ø7/8 x 3	2
1			-2		SPLINE	4140	Ø1-1/4 x 2-3/8	3
		B/O	-3	1	SOCKET HEAD CAP SCREW	STEEL	8-32 UNC x 3/16 MCMaster-CARR #91251A180	1
1		B/O	-4		SPRING PLUNGER		VLIER #S-50	1
			-5	1	HOUSING	SP	Ø1-1/2 x 3-5/8	4
			-6	1	HANDLE WELDMENT			5
1			-6A		HANDLE	1018	Ø1-1/4 x 7/8	6
2			-6B		HANDLE	STEEL	Ø3/8 x 1-3/4 MCMaster-CARR #98381A630 (MODIFIED)	7
			-7	1	KNOB	SP	Ø3/4 x 1/2	8
		B/O	-8	1	DOWEL PIN	STEEL	Ø3/32 x 5/8 MCMaster-CARR #98381A440	1
1		B/O	-9		DOWEL PIN	STEEL	Ø1/8 x 3/8 MCMaster-CARR #98381A470	1
		B/O	-10	1	DOWEL PIN	STEEL	Ø1/8 x 1 MCMaster-CARR #98381A475	1
1			-11		GUIDE	4140 Q&T	Ø1-1/8 x 3-7/8	9
			-12	1	ADAPTER	SP	Ø2 x 2-3/8	10
			-13	1	SPLINE ASSY.			11

RED BARN MACHINE

TITLE PULLER - COMPRESSOR ROTOR
SPLINED ADAPTER

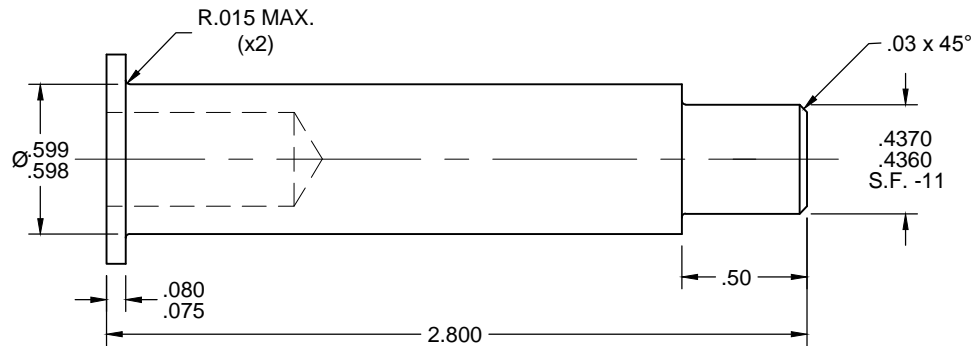
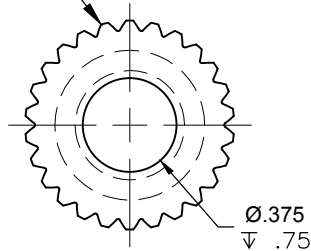
DWG NO. RB6891195 **REV** 1

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: CLOUGH
TOLERANCES ON:		APPROVED <i>D Weil</i>
DECIMALS .XXX ± .005	METRIC REF. .XXmm ± .1mm	HEAT TREAT FINISH
.XX ± .01	FRACTIONS ± 1/32	SPEC
.X ± .1	ANGLES ± 5°	USED ON MODEL
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		ROLLS-ROYCE 250 SERIES
SCALE NTS	DATE 7/8/11	SHEET 1 of 11

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC	DW

SEE SPLINE
DATA



(-1)
LOCATER

UNDER REVIEW

URF 19-947 19.10.23 (VM)

EXTERNAL INVOLUTED SPLINE DATA

NO. OF TEETH	26
PITCH	32/64
PRESSURE ANGLE	30°
BASE CIRCLE DIAMETER	.7036 REF.
MINOR DIAMETER	.757 MIN.
FORM DIAMETER	.777
PITCH DIAMETER	.8125 BASIC
MAJOR DIAMETER	.828-.844
FILLET RADIUS	.008 MIN.
TOOTH TIP BREAK	.005 MAX
CIRCULAR TOOTH THICKNESS	
MAX EFFECTIVE	.0491
MIN EFFECTIVE	.0478 REF.
MAX ACTUAL	.0477 REF.
MIN ACTUAL	.0464

SPLINE IN ACCORDANCE WITH ANS B92.
DIMENSION OVER TWO Ø.0600 PINS .9014-.9034 REF.

NOTES

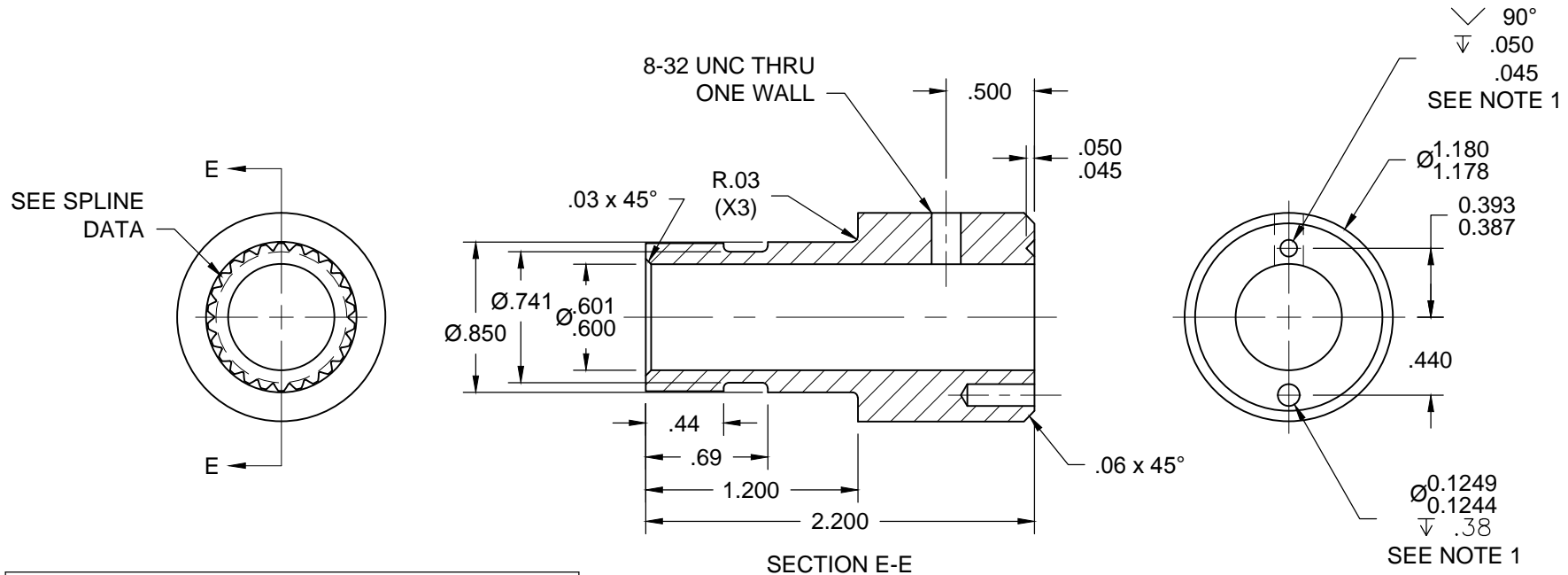
- THIS ITEM TO BE ASSEMBLED INTO -11,
REFER TO -13 ASSEMBLY FOR DETAILS.

RED BARN MACHINE	
TITLE PULLER - COMPRESSOR ROTOR SPLINED ADAPTER	
DWG NO. RB6891195-1	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	METRIC REF. .Xmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 7/8/11
SHEET 2 of 11	

DRAWN BY: CLOUGH
APPROVED <i>D Weil</i>
HEAT TREAT RC 36-40
FINISH BLACK OXIDE
SPEC
USED ON MODEL
ROLLS-ROYCE 250 SERIES

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC	DW
1	CH'D -2 DOWEL PIN HOLE FROM Ø.125 DEPTH .38 P.F. -9 SEE NOTE 1 PER G.E.	5/29/12	RJC	GE



EXTERNAL INVOLUTED SPLINE DATA

NO. OF TEETH	26
PITCH	32/64
PRESSURE ANGLE	30°
BASE CIRCLE DIAMETER	.7036 REF.
MINOR DIAMETER	.757 MIN.
FORM DIAMETER	.777
PITCH DIAMETER	.8125 BASIC
MAJOR DIAMETER	.828-.844
FILLET RADIUS	.008 MIN.
TOOTH TIP BREAK	.005 MAX
CIRCULAR TOOTH THICKNESS	
MAX EFFECTIVE	.0491
MIN EFFECTIVE	.0478 REF.
MAX ACTUAL	.0477 REF.
MIN ACTUAL	.0464

SPLINE IN ACCORDANCE WITH ANS B92.
DIMENSION OVER TWO Ø.0600 PINS .9014-.9034 REF.

UNDER REVIEW

② URF 19-947 19.10.23 (VM)
SPLINE

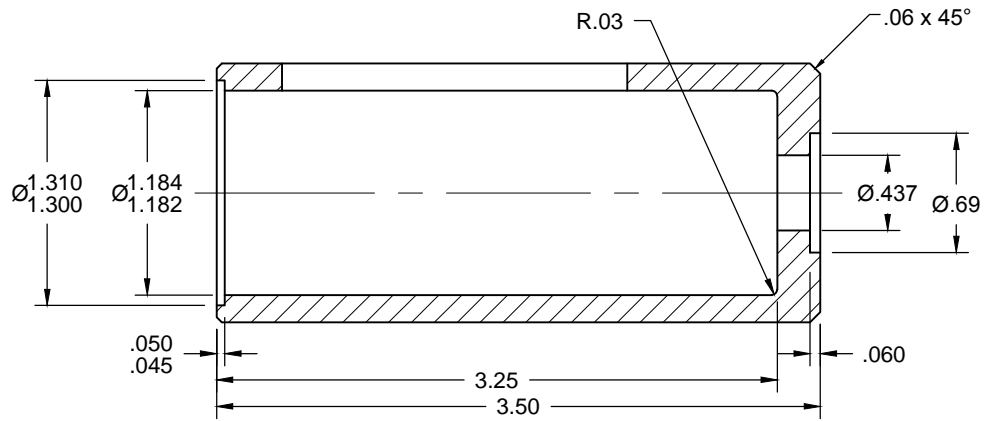
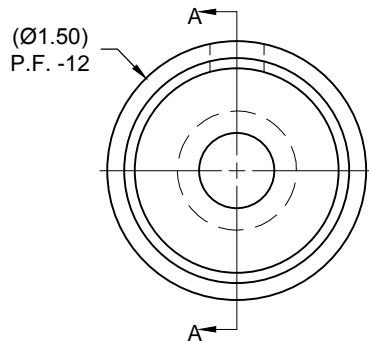
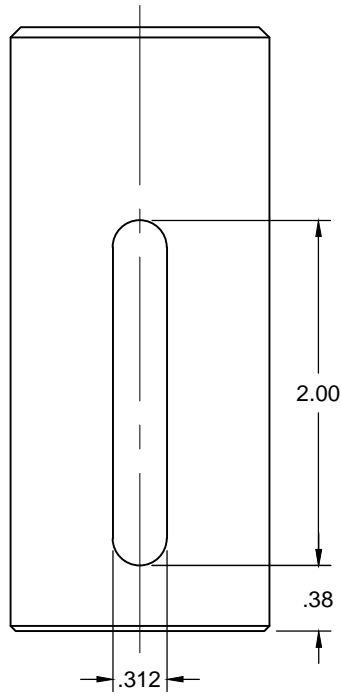
NOTES

1. TIME TO SPLINE TOOTH.

RED BARN MACHINE	
TITLE PULLER - COMPRESSOR ROTOR SPLINED ADAPTER	
DWG NO. RB6891195-2	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1	METRIC REF. .Xmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 7/8/11
SHEET 3 of 11	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC	DW



SECTION A-A

UNDER REVIEW

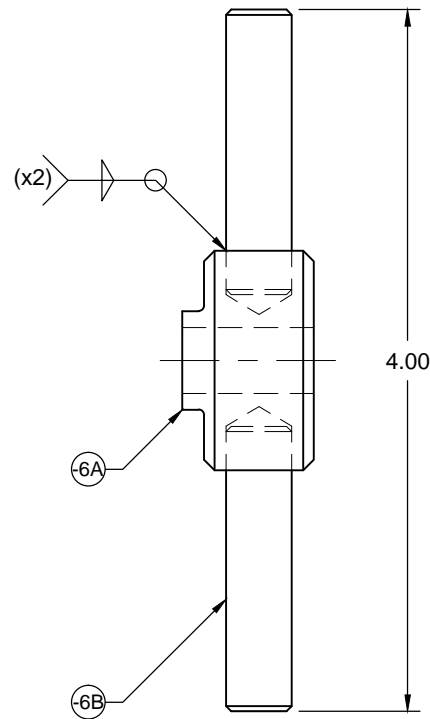
URF 19-947 19.10.23 (VM)

⑤
HOUSING

RED BARN MACHINE	
TITLE PULLER - COMPRESSOR ROTOR SPLINED ADAPTER	
DWG NO. RB6891195-5	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 METRIC REF. .Xmm ± .1mm .XX ± .01 FRACTIONS ± 1/32 X ± .1 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 7/8/11
SHEET 4 of 11	
DRAWN BY: CLOUGH APPROVED: <i>D Weil</i> HEAT TREAT: BLACK OXIDE SPEC: USED ON MODEL ROLLS-ROYCE 250 SERIES	


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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC	DW



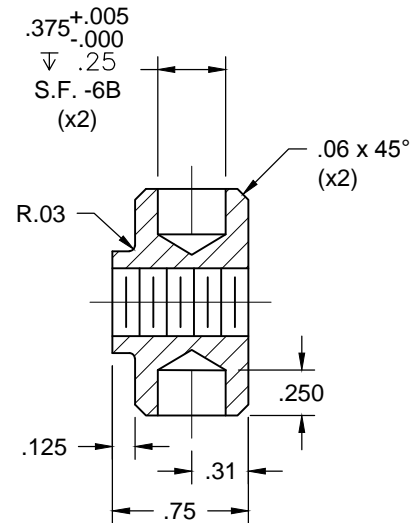
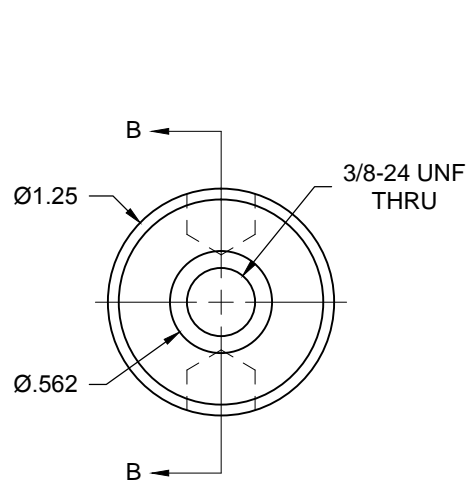
(6)
HANDLE WELDMENT

UNDER REVIEW
URF 19-947 19.10.23 (VM)

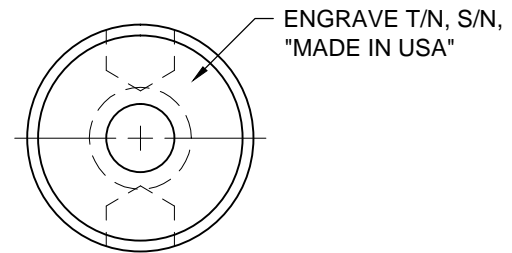
 RED BARN MACHINE	
TITLE PULLER - COMPRESSOR ROTOR SPLINED ADAPTER	
DWG NO. RB6891195-5	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX \pm .005 XX \pm .01 X \pm .1	METRIC REF. .Xmm \pm .1mm FRACTIONS \pm 1/32 ANGLES \pm 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: CLOUGH APPROVED <i>D Weil</i> HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL ROLLS-ROYCE 250 SERIES
SCALE NTS	DATE 7/8/11 SHEET 5 of 11

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC	DW




SECTION B-B



UNDER REVIEW

URF 19-947 19.10.23 (VM)

(-6A)
HANDLE

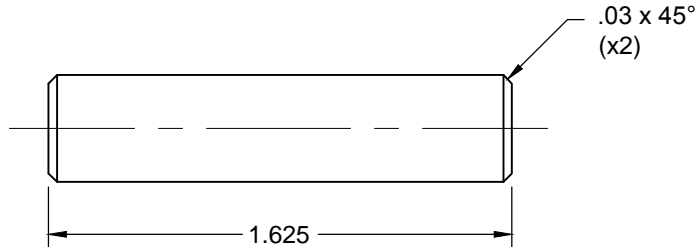
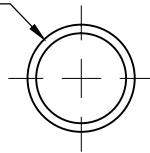
 RED BARN MACHINE	
TITLE PULLER - COMPRESSOR ROTOR SPLINED ADAPTER	
DWG NO. RB6891195-6A	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	METRIC REF. .Xmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 7/8/11
SHEET 6 of 11	

DRAWN BY: CLOUGH
APPROVED <i>D Weil</i>
HEAT TREAT
FINISH SEE WELDMENT
SPEC
USED ON MODEL
ROLLS-ROYCE 250 SERIES

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC	DW

(Ø.375)
S.F. -6A




(-6B)

HANDLE

UNDER REVIEW

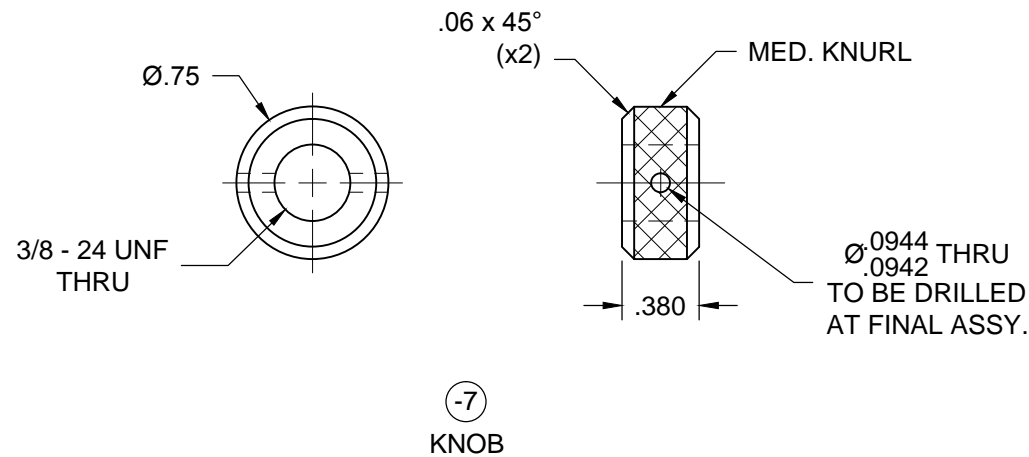
URF 19-947 19.10.23 (VM)

 RED BARN MACHINE	
TITLE PULLER - COMPRESSOR ROTOR SPLINED ADAPTER	
DWG NO. RB6891195-6B	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 METRIC REF. .Xmm ± .1mm .XX ± .01 FRACTIONS ± 1/32 .X ± .1 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 7/8/11
SHEET 7 of 11	

DRAWN BY: CLOUGH
APPROVED <i>D Weil</i>
HEAT TREAT
FINISH SEE WELDMENT
SPEC
USED ON MODEL
ROLLS-ROYCE 250 SERIES


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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC	DW
1	CH'D -7 HOLE CALL-OUT FROM Ø.0937--.0932 THRU S.F. -8 AT ASSY. PER G.E.	5/29/12	RJC	GE



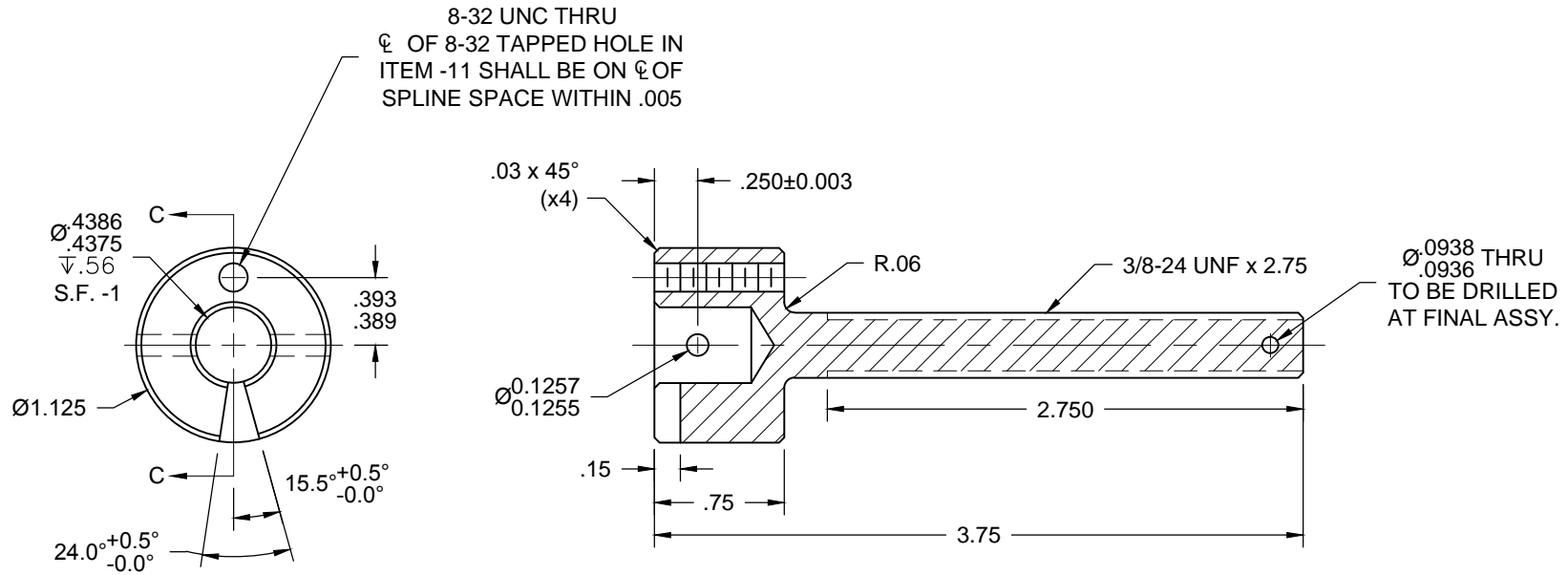
UNDER REVIEW

URF 19-947 19.10.23 (VM)

 RED BARN MACHINE	
TITLE PULLER - COMPRESSOR ROTOR SPLINED ADAPTER	
DWG NO. RB6891195-7	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS .XX ± .01 ANGLES X ± .1	METRIC REF. .Xmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: CLOUGH APPROVED: <i>D Weil</i> HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL ROLLS-ROYCE 250 SERIES
SCALE NTS	DATE 7/8/11 SHEET 8 of 11

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC	DW
1	CH'D -11 HOLE FROM $\phi .0937-.0928$ P.F. -8 AT ASSY. & ADDED MISSING DOWEL PIN HOLE & ADDED $.250 \pm .003$ DIMENSION PER G.E.	5/29/12	RJC	GE



SECTION C-C

-11
 GUIDE

NOTES

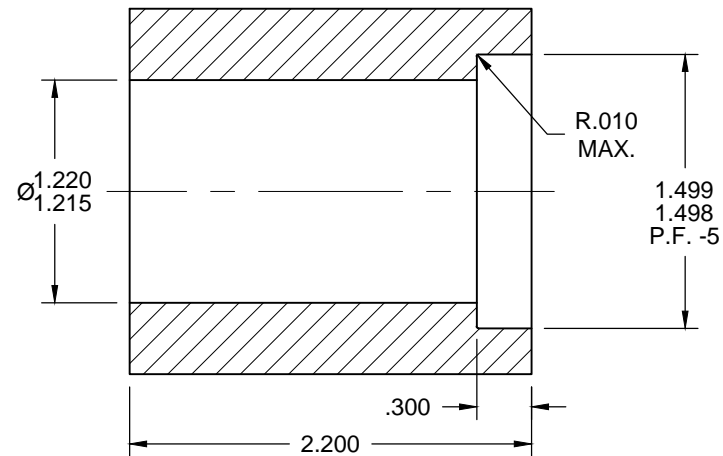
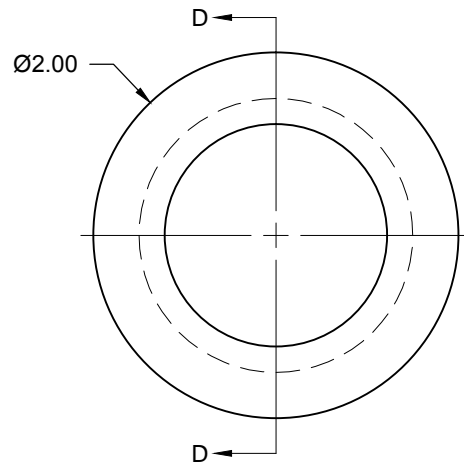
- THIS ITEM TO BE ASSEMBLED INTO -1,
 REFER TO -13 ASSEMBLY FOR DETAILS.

UNDER REVIEW
 URF 19-947 19.10.23 (VM)

RED BARN MACHINE	
TITLE PULLER - COMPRESSOR ROTOR SPLINED ADAPTER	
DWG NO. RB6891195-11	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 XX ± .01 X ± .1	METRIC REF. .Xmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 7/8/11
SHEET 9 of 11	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC	DW




SECTION D-D

UNDER REVIEW

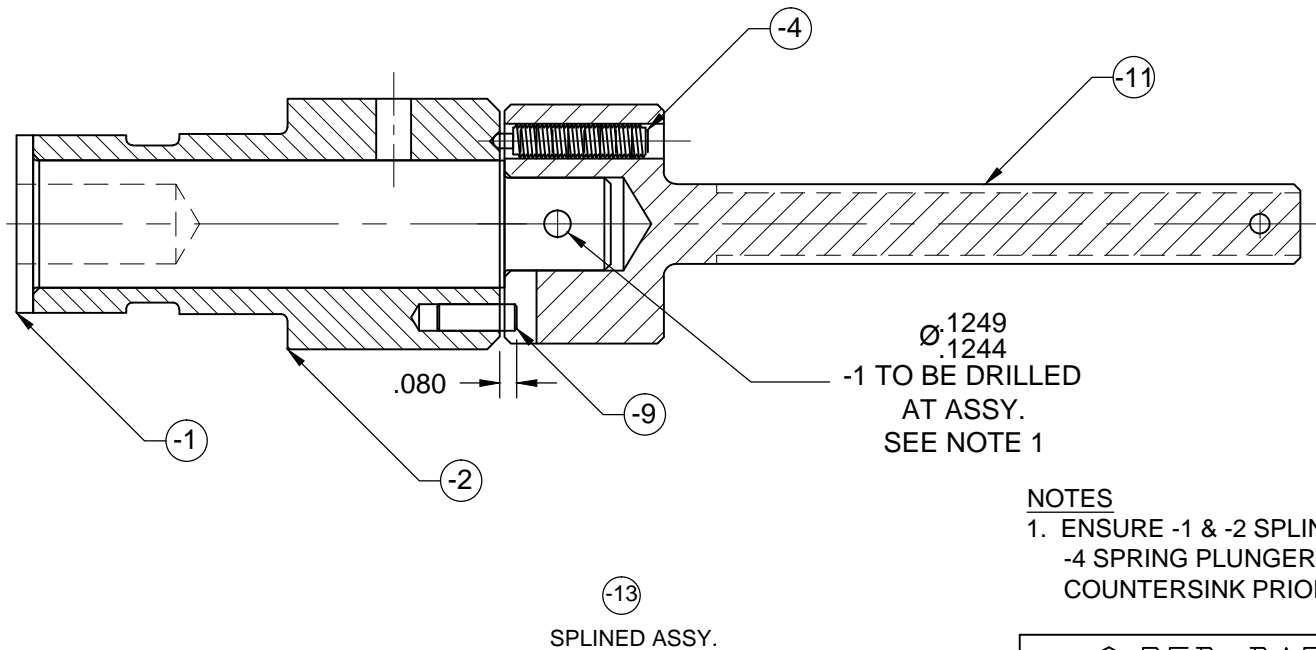
URF 19-947 19.10.23 (VM)

(-12)
ADAPTER

 RED BARN MACHINE	
TITLE PULLER - COMPRESSOR ROTOR SPLINED ADAPTER	
DWG NO. RB6891195-12	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1 METRIC REF. .XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: CLOUGH APPROVED <i>D Weil</i> HEAT TREAT FINISH BLACK OXIDE SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL ROLLS-ROYCE 250 SERIES
SCALE NTS	DATE 7/8/11 SHEET 10 of 11

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
B	REDRAWN FROM TATTERED ORIGINAL PER D.W.	9/16/11	RJC	DW
1	CH'D -13 HOLE FROM ϕ .1250-.1245 P.F. -10 AT ASSY. PER G.E.	5/29/12	RJC	GE



NOTES

1. ENSURE -1 & -2 SPLINES ARE ALIGNED AND -4 SPRING PLUNGER IS ALIGNED WITH COUNTERSINK PRIOR TO DRILLING HOLE.

UNDER REVIEW
URF 19-947 19.10.23 (VM)

RED BARN MACHINE	
TITLE PULLER - COMPRESSOR ROTOR SPLINED ADAPTER	
DWG NO. RB6891195-13	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX \pm .005 XX \pm .01 X \pm .1	
METRIC REF. Xmm \pm .1mm FRACTIONS \pm 1/32 ANGLES \pm 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 7/8/11
SHEET 11 of 11	

DRAWN BY: CLOUGH
APPROVED <i>D Weil</i>
HEAT TREAT
FINISH BLACK OXIDE
SPEC
USED ON MODEL
ROLLS-ROYCE 250 SERIES

NOT APPROVED FOR PRODUCTION

URF 19-947 19.10.23 (VM)

NOT APPROVED FOR PRODUCTION

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

NOT APPROVED FOR PRODUCTION

UNDER REVIEW

URF 19-947 19.10.23 (VM)

RED BARN MACHINE
190 South Danebo Ave
Eugene, Oregon 97402
(541) 344-9953; Fax 344-3863
E-mail: sales@redbarn.net

 RED BARN MACHINE	
TITLE INSPECTION & TESTING PROCEDURES FOR THE FIRE SCOUT ENGINE LIFT ASSEMBLY	
TOOL NO. RBT18717	
CUSTOMER 1 of 1	
SHEET 5 of 5	